



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.4001

Job Sheet 203267



Part No: 646.4001

Job Qty: 1 pcs

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/19

Job Tracking No:

Due Date: 12/13/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	12/13/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
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							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartero.com
www.dartaerospace.com



Container No: S260511



Part: 646.4001

Job No: 203267

Serial No/Batch: S260511

Revision:

Inspector:

Exp D-12

Instru tions: F A STC S.0218

A 14/1

07/02/19

TC: M35

[https://www.plexonline.com/B12A4B9D-52F7-4913-B9FC-41D61774CDFS/Plexus Control/Report Viewer 2.asp?URL=../Part/Job Sheet.asp&Report...](https://www.plexonline.com/B12A4B9D-52F7-4913-B9FC-41D61774CDFS/Plexus%20Control/Report%20Viewer%202.asp?URL=../Part/Job%20Sheet.asp&Report...) 2/5

- 130 - Identify and pack for shipping as per PPP 646.4001 Location: _____
 135 - Document Control - Photocopy bluefile & type labels per PPP 646.4001
 140 - QC21- Final Inspection - Work Order Release

2141694

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	110-Packaging 1 - Pick Kit	5215203
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5241630
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5241651
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5263461
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5221172
646.2910	Deflector	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5200995
646.3001	Lower Cable Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5243886
646.3110	Channel	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5233062
646.3210	Support	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5221454
646.3301	Upper Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5255306
646.3510	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5187754
646.3511	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5183035
646.3610	Filler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5236345
646.3710	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5244287
646.3711	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5218358
646.3712	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5219276
646.3713	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5219291
646.3714	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5197814
646.3715	Strut Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5218112
646.3716	Gauge Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5233890
646.3717	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5196396
646.3718	Custom Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5219261
646.3719	Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5218795
646.3810	Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5220046
646.3811	Radius Block	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5229075
646.3812	Gusset Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5220084
646.3813	AS350 Strut Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5171341
646.3910	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5218108
646.3911	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5220038
646.3912	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5218498
646.3913	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5218110
646.9410	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5056998
647.0112	Strut Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5258631
647.7703	Strut Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5243472
650.9201	Eyelet Bracket Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5239406
AN3-11A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5249339
AN3-12A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	516926
AN3-13A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5208738
AN3-3A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5253401
AN3-4A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5253438
AN3-5A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5216385
AN3-6A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5194345
AN316C4R	Nut, Jam	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5227999
AN44-5A	Eyebolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5216370
AN4C7A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5222451
AN665-34R	Clevis	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5239635
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	110-Packaging 1 - Pick Kit	5218602
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	110-Packaging 1 - Pick Kit	5235458
MS20426AD5-7	Rivet	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	52133922-36
MS20470AD5-5-5	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5155875
MS20470AD5-6	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5248694
MS20470AD5-7	Rivet	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5203251
MS21042L08	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5250462
MS21042L3	Nut	63 Ea (63 ea)	110-Packaging 1 - Pick Kit	5246081
MS21042L4	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5225639
MS21047-3	Nut Plate	18 Ea (18 ea)	110-Packaging 1 - Pick Kit	5216288

MS24693-C278	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5202672
MS24694-S51	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5185069
MS24694-S54	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5228823
MS24694-S55	Screw	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5247925
MS27039-08-13	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5247871
MS27039-1-10	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5231296
MS27039-1-12	Screw	6 Ea (6 ea)	110-Packaging 1 - Pick Kit	5193131
MS27039-1-16	Screw	24 Ea (24 ea)	110-Packaging 1 - Pick Kit	5157063
MS27039-1-19	Screw	22 Ea (22 ea)	110-Packaging 1 - Pick Kit	5123443
MS27039-1-20	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5228014
MS27039-1-21	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5171793
NAS1149F0332P	Washer (AN960-10L)	144 Ea (144 ea)	110-Packaging 1 - Pick Kit	5249217x140/5237
NAS1149F0363P	Washer (AN960-10)	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5075336
NAS1149F0432P	Washer (AN960-416L)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5235429
NAS1149FN832P	Washer (AN960-8)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5248080

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0129	8	418	0
	600.0990	1	24	0
	600.0991	1	24	0
	600.1012	1	34	0
	600.1013	5	115	0
	646.2910	1	18	0
	646.3001	1	5	0
	646.3110	1	12	0
	646.3210	1	27	0
	646.3301	1	6	0
	646.3510	1	34	0
	646.3511	1	35	0
	646.3610	1	29	0
	646.3710	1	23	0
	646.3711	1	32	0
	646.3712	1	37	0
	646.3713	1	35	0
	646.3714	1	36	0
	646.3715	2	40	0
	646.3716	1	26	0
	646.3717	1	22	0
	646.3718	2	61	0
	646.3719	2	44	0
	646.3810	2	33	0
	646.3811	1	44	0
	646.3812	2	36	0
	646.3813	1	22	0
	646.3910	4	45	0
	646.3911	1	52	0
	646.3912	4	77	0
	646.3913	1	29	0
	646.9410	1	46	0
	647.0112	2	82	0
	647.7703	2	26	0
	650.9201	2	31	0
	AN3-11A	10	369	0
	AN3-12A	2	122	0
	AN3-13A	1	77	0
	AN3-3A	4	487	0
	AN3-4A	10	431	0
	AN3-5A	2	252	0
	AN3-6A	2	223	0
	AN316C4R	2	71	0
	AN44-5A	2	49	0
	AN4C7A	2	159	0
	AN665-34R	2	33	0
	CCR264SS3-02	36	1,108	0
	CR3213-5-3	14	390	0
	MS20426AD5-7	2	595	0
	MS20470AD5-5-5	8	745	0
	MS20470AD5-6	8	582	0

MS20470AD5-7	3	1,014	0
MS21042L08	2	939	0
MS21042L3	63	2,396	0
MS21042L4	2	5,479	0
MS21047-3	18	404	0
MS24693-C278	5	76	0
MS24694-S51	5	228	0
MS24694-S54	2	380	0
MS24694-S55	3	186	0
MS27039-08-13	2	286	0
MS27039-1-10	2	402	0
MS27039-1-12	6	357	0
MS27039-1-16	24	492	0
MS27039-1-19	22	369	0
MS27039-1-20	2	144	0
MS27039-1-21	4	99	0
NAS1149F0332P	144	4,820	0
NAS1149F0363P	2	285	0
NAS1149F0432P	4	948	0
NAS1149FN832P	4	2,082	0

Part Specifications

Specifications could not be found.

Plex 11/14/19 7:50 AM Dart.lajeunesse.marie

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality			
Date :	Sequence #:	QTY Affected :		MRB (QS042)			
Description Work Order Deviation		Disposition					
		Completed By					
		Lead hand / Supervisor					
		QC / QA Coordinator					

Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread									
		Other/Details:									

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NOTES:

1. AFTER INSTALLATION, APPLY F/N 54 AIR TO TIL GAPS AND HOLE EDGES.

2. INSTALL F/N 14 WITH F/N 52 & 53.

3. 3M VHB ADHESIVE TAPE, 0.25" THICK X 50" WIDE
VENDOR: MCMMASTER-CARR P/N 75955A-651.

4. 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES AIR BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

5. REUSE FASTENERS FROM F/N 1.

6. USE WASHERS AIR AS SHIMS TO OBTAIN BEST FITMENT.

7. AT CUSTOMER'S OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8. INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT FIT. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9. NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

QTY	REV	DESCRIPTION	DATE	BY	CHKD	APP'D	REVISION
1	1	601.2829 SCREW	02/08/2010	W. BROWN			
2	2	601.2831 RIVET	02/08/2010	W. BROWN			
3	3	646.3716 GAUGE BRACKET	02/08/2010	W. BROWN			
4	4	601.1953 SCREW	02/08/2010	W. BROWN			
5	5	646.3715 STRUT DOUBLER	02/08/2010	W. BROWN			
6	6	601.2824 RIVET	02/08/2010	W. BROWN			
7	7	601.2227 RIVET	02/08/2010	W. BROWN			
8	8	600.0955 RIVET	02/08/2010	W. BROWN			
9	9	601.2545 RIVET	02/08/2010	W. BROWN			
10	10	646.3813 STRUT BRACKET	02/08/2010	W. BROWN			
11	11	601.2822 RIVET	02/08/2010	W. BROWN			
12	12	646.3812 GUSSET BRACKET	02/08/2010	W. BROWN			
13	13	601.2544 RIVET	02/08/2010	W. BROWN			
14	14	646.3714 GUSSET	02/08/2010	W. BROWN			
15	15	646.3610 TILTER	02/08/2010	W. BROWN			
16	16	601.2530 SCREW	02/08/2010	W. BROWN			
17	17	601.2825 RIVET	02/08/2010	W. BROWN			
18	18	646.3811 RADIUS BLOCK	02/08/2010	W. BROWN			
19	19	646.3712 CLIP	02/08/2010	W. BROWN			
20	20	601.2832 RIVET	02/08/2010	W. BROWN			
21	21	601.2020 RIVET	02/08/2010	W. BROWN			
22	22	601.2823 RIVET	02/08/2010	W. BROWN			
23	23	601.2827 RIVET	02/08/2010	W. BROWN			
24	24	601.2912 GUSSET	02/08/2010	W. BROWN			
25	25	646.3713 GUSSET	02/08/2010	W. BROWN			
26	26	646.3210 SUPPORT	02/08/2010	W. BROWN			
27	27	646.3710 DOUBLER	02/08/2010	W. BROWN			
28	28	646.3110 CHANNEL	02/08/2010	W. BROWN			
29	29	601.1624 LOCKNUT	02/08/2010	W. BROWN			
30	30	601.1627 WASHER	02/08/2010	W. BROWN			
31	31	646.3410 PH WIPER DIRECTOR	02/08/2010	W. BROWN			
32	32	646.3411 STRUT ASSEMBLY	02/08/2010	W. BROWN			
33	33	647.7703 STRUT BRACKET	02/08/2010	W. BROWN			
34	34	646.3511 STRUT	02/08/2010	W. BROWN			
35	35	646.3510 STRUT	02/08/2010	W. BROWN			
36	36	646.3510 STRUT	02/08/2010	W. BROWN			
37	37	646.3510 STRUT	02/08/2010	W. BROWN			
38	38	646.3510 STRUT	02/08/2010	W. BROWN			
39	39	646.3510 STRUT	02/08/2010	W. BROWN			
40	40	646.3510 STRUT	02/08/2010	W. BROWN			
41	41	646.3510 STRUT	02/08/2010	W. BROWN			
42	42	646.3510 STRUT	02/08/2010	W. BROWN			
43	43	646.3510 STRUT	02/08/2010	W. BROWN			
44	44	646.3510 STRUT	02/08/2010	W. BROWN			
45	45	646.3510 STRUT	02/08/2010	W. BROWN			
46	46	646.3510 STRUT	02/08/2010	W. BROWN			
47	47	646.3510 STRUT	02/08/2010	W. BROWN			
48	48	646.3510 STRUT	02/08/2010	W. BROWN			
49	49	646.3510 STRUT	02/08/2010	W. BROWN			
50	50	646.3510 STRUT	02/08/2010	W. BROWN			
51	51	646.3510 STRUT	02/08/2010	W. BROWN			
52	52	646.3510 STRUT	02/08/2010	W. BROWN			
53	53	646.3510 STRUT	02/08/2010	W. BROWN			
54	54	646.3510 STRUT	02/08/2010	W. BROWN			
55	55	646.3510 STRUT	02/08/2010	W. BROWN			
56	56	646.3510 STRUT	02/08/2010	W. BROWN			
57	57	646.3510 STRUT	02/08/2010	W. BROWN			
58	58	646.3510 STRUT	02/08/2010	W. BROWN			
59	59	646.3510 STRUT	02/08/2010	W. BROWN			
60	60	646.3510 STRUT	02/08/2010	W. BROWN			
61	61	646.3510 STRUT	02/08/2010	W. BROWN			
62	62	646.3510 STRUT	02/08/2010	W. BROWN			
63	63	646.3510 STRUT	02/08/2010	W. BROWN			
64	64	646.3510 STRUT	02/08/2010	W. BROWN			
65	65	646.3510 STRUT	02/08/2010	W. BROWN			
66	66	646.3510 STRUT	02/08/2010	W. BROWN			
67	67	646.3510 STRUT	02/08/2010	W. BROWN			
68	68	646.3510 STRUT	02/08/2010	W. BROWN			
69	69	646.3510 STRUT	02/08/2010	W. BROWN			
70	70	646.3510 STRUT	02/08/2010	W. BROWN			
71	71	646.3510 STRUT	02/08/2010	W. BROWN			
72	72	646.3510 STRUT	02/08/2010	W. BROWN			
73	73	646.3510 STRUT	02/08/2010	W. BROWN			
74	74	646.3510 STRUT	02/08/2010	W. BROWN			
75	75	646.3510 STRUT	02/08/2010	W. BROWN			
76	76	646.3510 STRUT	02/08/2010	W. BROWN			
77	77	646.3510 STRUT	02/08/2010	W. BROWN			
78	78	646.3510 STRUT	02/08/2010	W. BROWN			
79	79	646.3510 STRUT	02/08/2010	W. BROWN			
80	80	646.3510 STRUT	02/08/2010	W. BROWN			
81	81	646.3510 STRUT	02/08/2010	W. BROWN			
82	82	646.3510 STRUT	02/08/2010	W. BROWN			
83	83	646.3510 STRUT	02/08/2010	W. BROWN			
84	84	646.3510 STRUT	02/08/2010	W. BROWN			
85	85	646.3510 STRUT	02/08/2010	W. BROWN			
86	86	646.3510 STRUT	02/08/2010	W. BROWN			
87	87	646.3510 STRUT	02/08/2010	W. BROWN			
88	88	646.3510 STRUT	02/08/2010	W. BROWN			
89	89	646.3510 STRUT	02/08/2010	W. BROWN			
90	90	646.3510 STRUT	02/08/2010	W. BROWN			
91	91	646.3510 STRUT	02/08/2010	W. BROWN			
92	92	646.3510 STRUT	02/08/2010	W. BROWN			
93	93	646.3510 STRUT	02/08/2010	W. BROWN			
94	94	646.3510 STRUT	02/08/2010	W. BROWN			
95	95	646.3510 STRUT	02/08/2010	W. BROWN			
96	96	646.3510 STRUT	02/08/2010	W. BROWN			
97	97	646.3510 STRUT	02/08/2010	W. BROWN			
98	98	646.3510 STRUT	02/08/2010	W. BROWN			
99	99	646.3510 STRUT	02/08/2010	W. BROWN			
100	100	646.3510 STRUT	02/08/2010	W. BROWN			

REV		DESCRIPTION	DATE	BY	CHKD	APP'D	REVISION
A	1	ASSEMBLY BLOCK 2716 (2001, 2011 & 2012)	02/08/2010	J. BROWN			
B	1	ASSEMBLY BLOCK 2716 (2001, 2011 & 2012)	02/08/2010	J. BROWN			
C	1	ASSEMBLY BLOCK 2716 (2001, 2011 & 2012)	02/08/2010	J. BROWN			

REV	DESCRIPTION	DATE	BY	CHKD	APP'D	REVISION
A	ASSEMBLY BLOCK 2716 (2001, 2011 & 2012)	02/08/2010	J. BROWN			
B	ASSEMBLY BLOCK 2716 (2001, 2011 & 2012)	02/08/2010	J. BROWN			
C	ASSEMBLY BLOCK 2716 (2001, 2011 & 2012)	02/08/2010	J. BROWN			

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